

Work Order ID 64253

Tuesday, November 30, 2010 4:07:11 PM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 11/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-01-12 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3913	A

100 Weld per dwg A/R S.S. rod Batch: *4114649* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh
 2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit if necessary
 and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

10/12/22

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-01-03 *PL*

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Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Base Assembly, 350

Start Date: 11/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8 11/01/03

(X)

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00






Hand Finishing



1 BK 11-01-3



Work Order ID 64253

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Page 3

Item ID:	D3913-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Base Assembly, 350					
Start Date:	11/30/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	12/10/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M115951</i> Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat 1ST COAT: START TIME: <i>10:10</i> OVEN TEMPERATURE: <i>1600°</i> FINISH TIME: <i>10:40</i> ***** 2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				<i>1</i>	<i>BR</i>	<i>11-01-3</i>	
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>8/10/10/06</i>		<i>(40)</i>			

Work Order ID 64253

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Item ID: D3913-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Base Assembly, 350

Start Date: 11/30/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Assemble as per dwg

0.00

=> ML 11/01/04

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: B64252 0.00

0.00

Packaging

Memo

0.00

Packaging

Work Order ID 64253

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Page 5

Item ID: D3913-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Base Assembly, 350

Start Date: 11/30/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

OK 12/01/07

CMF

11-01-07

Picklist Print

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Page 1

Work Order ID: 64253

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350



Start Date: 11/30/2010

Required Date: 12/10/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2581 Mounting Bracket		Manufactured	No			100	Each	23.0000	2	2			
---------------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA	23	
61953	20	
63493	3	

✓ D3913-1 Rib		Manufactured	No			100	Each	5.0000	1	1			
----------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA	5	
60674	1	
60731	3	
63752	1	

✓ D3913-15 Wide Handle Plate		Manufactured	No			100	Each	6.0000	1	1			
-------------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA	6	
60732	3	
63627	3	

B64925 @ 10/12/21

10/12/21

10/12/21

(1x)

(1x)

Picklist Print

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Page 3

Work Order ID: 64253

Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 11/30/2010



Required Date: 12/10/2010

Start Qty: 1.00



Required Qty: 1.00

✓ D3916-5 Manufactured No 100 Each 14.0000 3 3

 Light Rib  BY 10/12/21

Location	Loc Qty	Loc Code
WA	14	
57023	2	
60721	3	
63856	9	

✓ D4016-1 Manufactured No 100 Each 9.0000 3 3

 Hinge Half, Base  BY 10/12/21

Location	Loc Qty	Loc Code
WA	9	
63626	9	

✓ D4017-7 Manufactured No 100 Each 7.0000 1 1

 Rib  BY 10/12/21

Location	Loc Qty	Loc Code
WA	7	
58929	2	
61063	2	
63619	3	

✓ D4017-9 Manufactured No 100 Each 2.0000 2 2

 Rib  B 63632 2 BY 10/12/21

Location	Loc Qty	Loc Code
WA	2	
60262	2	

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Shop Packet Print

Page 3

Picklist Print

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Page 5

Work Order ID: 64253

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 11/30/2010

Required Date: 12/10/2010

Start Qty: 1.00

Required Qty: 1.00

D4034-043 Manufactured No

100

Each

1.0000

1

1



Fwd Upper Rib Assembly



B63620 (1x) 11/10/2010

Location

Loc Qty

Loc Code

WA

1

61065

1

AN3-10A Purchased No

150

Each

73.0000

6

6



Bolt



11/10/10

Location

Loc Qty

Loc Code

ST351

73

115877

29

116075

44

AN960JD8 NAS1149DN832 Purchased No

150

Each

10.0000

2

2



Washer



11/11/10

Location

Loc Qty

Loc Code

ST347

10

105059

10

D2931 Manufactured No

150

Each

760.0000

2

2



Bumper



11/11/10

Location

Loc Qty

Loc Code

ST504

760

46064

760

11/11/10

Picklist Print

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Work Order ID: 64253

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 11/30/2010

Required Date: 12/10/2010

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150

Each

1.0000

2

2



Blanking Plate



11/01/04

Location

Loc Qty

Loc Code

ST111

1

B 64243

Y2

60717

1

MS20600-AD4W3

Purchased

No

150

Each

1,443.000

2

2



Cherry Rivets



11/14/04

Location

Loc Qty

Loc Code

ST321

1443

107939

754

111636

689

MS21042L3

Purchased

No

150

Each

1,515.000

6

6



Nut



11/01/04

Location

Loc Qty

Loc Code

ST300

1515

114784

519

115835

996

NAS1149F0332P

Purchased

No

150

Each

451.0000

12

12



WASHER



11/01/04

Location

Loc Qty

Loc Code

ST275

451

18057

451

X12

Tuesday, November 30, 2010 4:07:15 PM

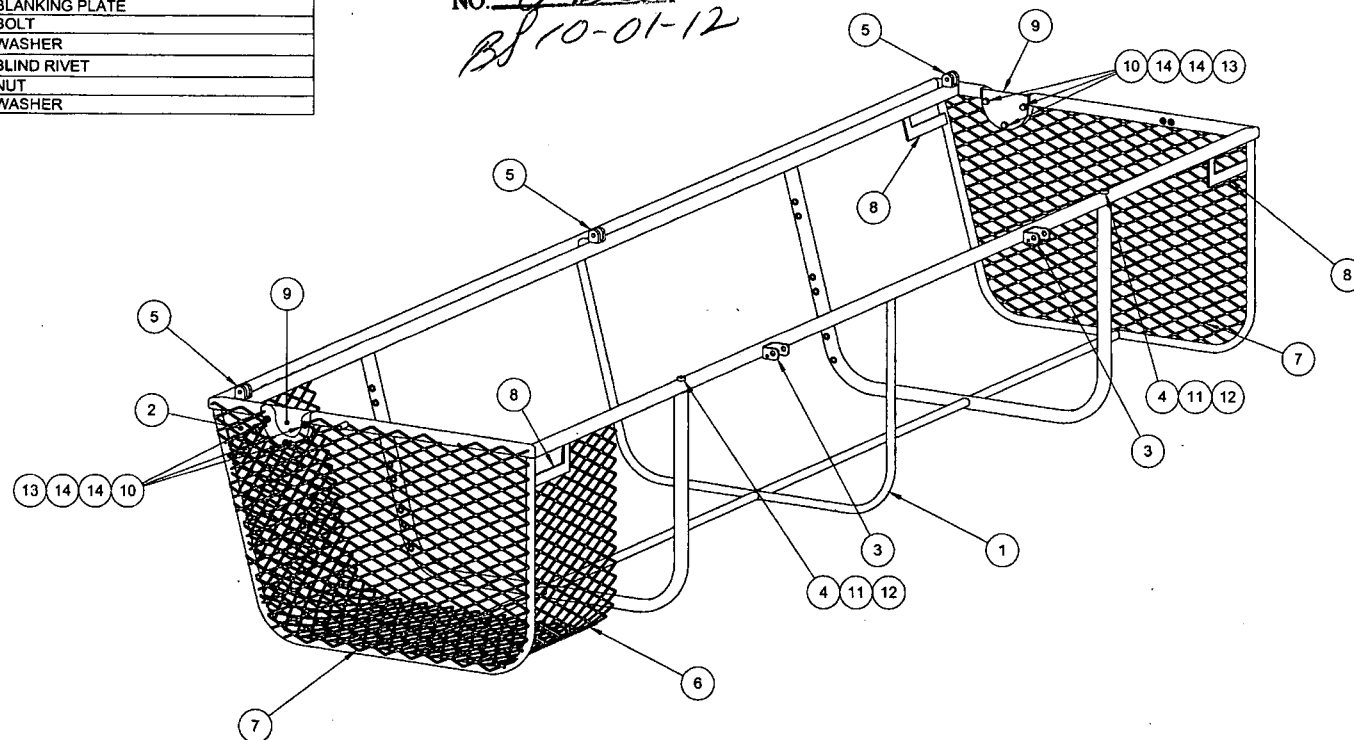
Shop Packet Print

Page 6

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-105	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER

SHOT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 64253
BS 10-01-12



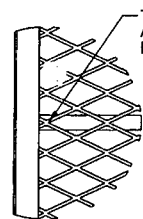
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

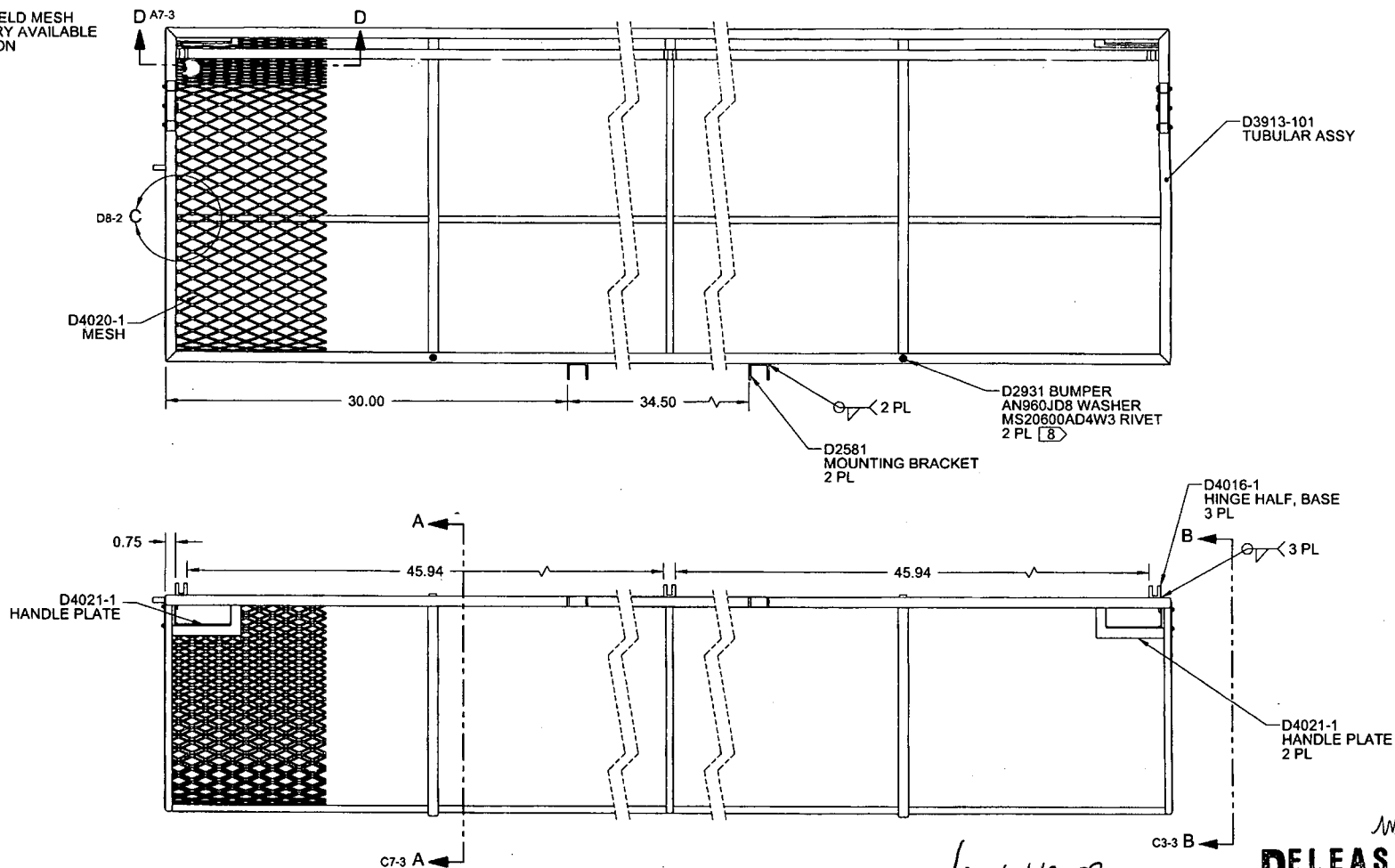
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3913 REV. A SHEET 1 OF 6 TITLE LONG BASKET BASE ASSY (350) NTS SCALE DATE 10.03.16	
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	







DETAIL C D7-2

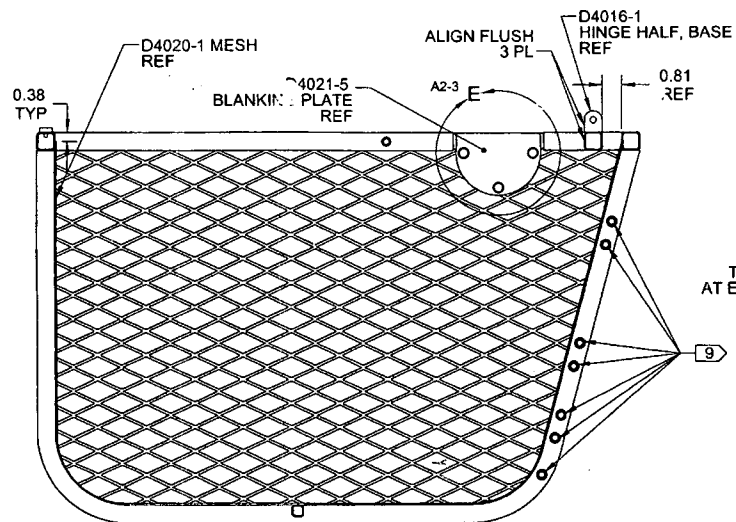


D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

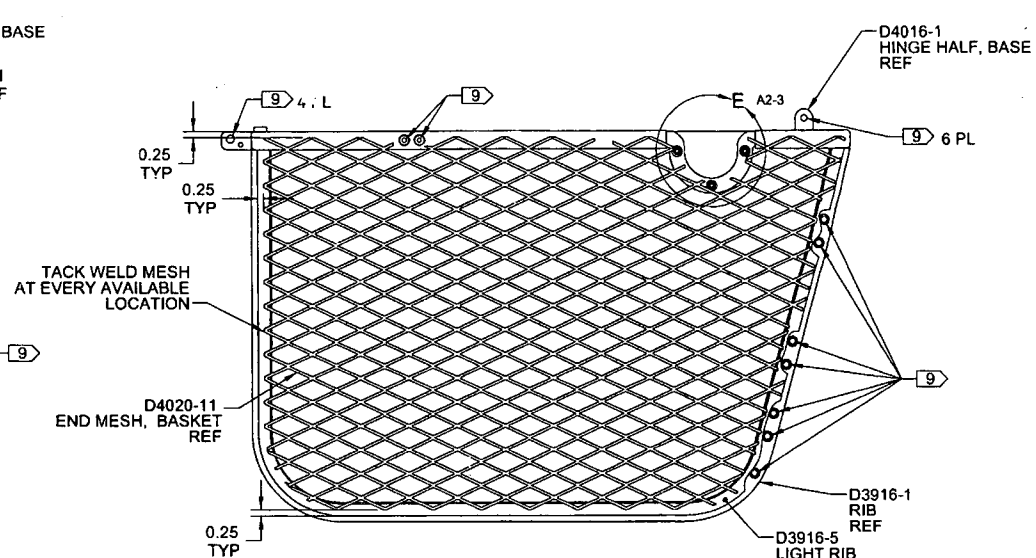
w/o 64253

RELEASED
2010-05-27

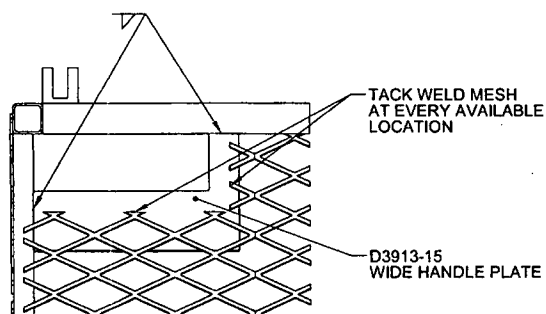
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JRH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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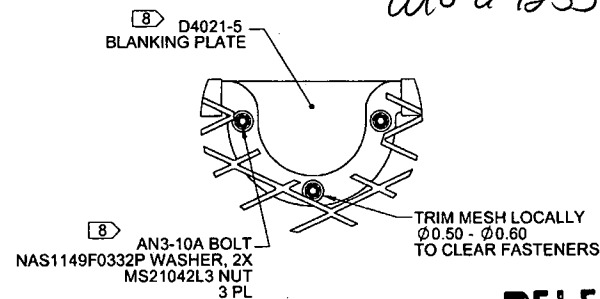
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES

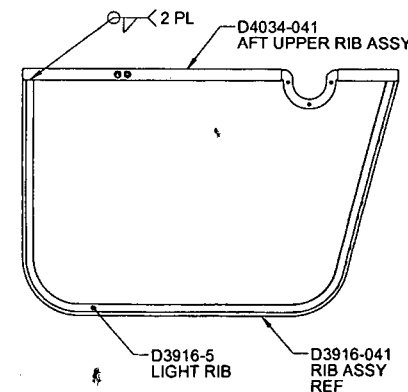
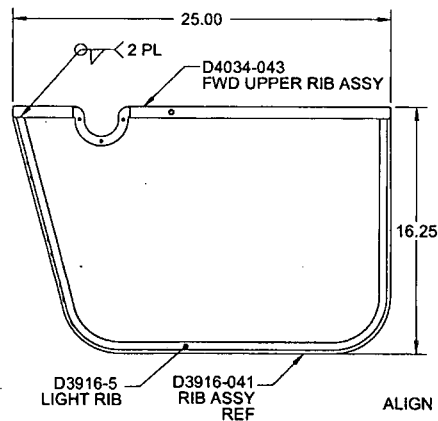
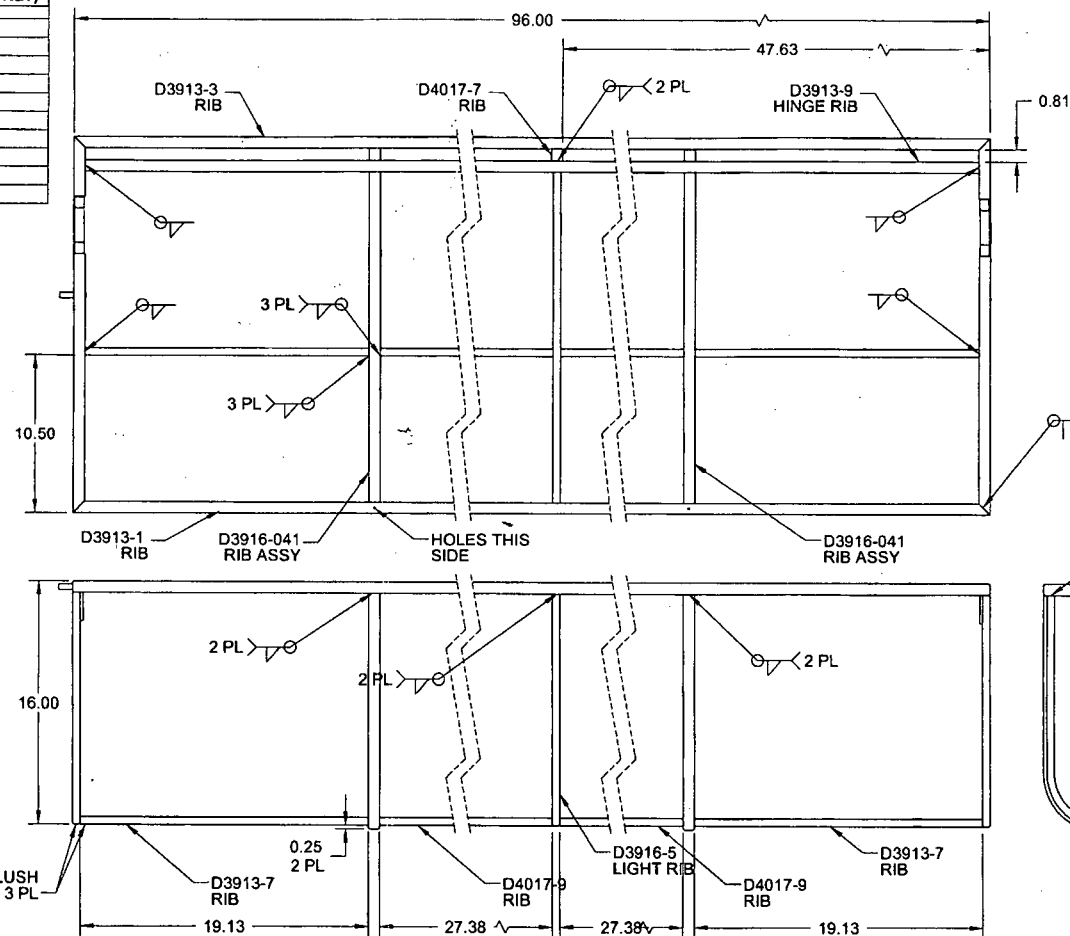


DETAIL E D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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RELEASED
2010-03-22

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



ALIGN FLUSH
3 PL

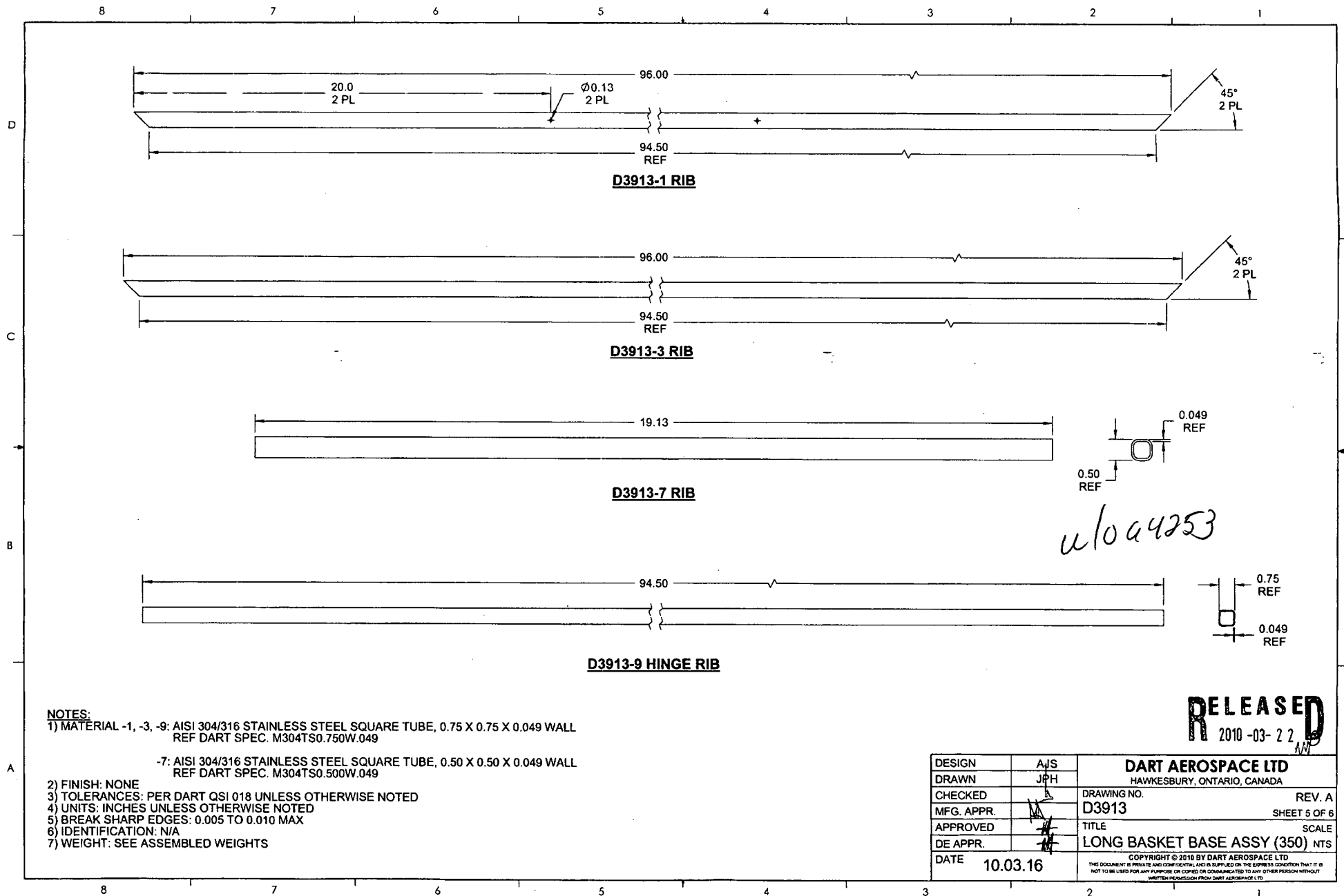
D3913-101 TUBULAR ASSY (350 SHORT BASKET)

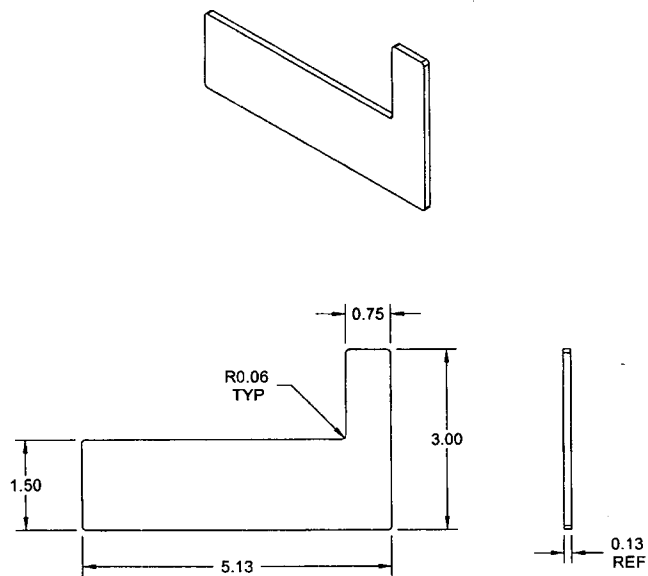
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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RELEASED
2010-03-22





D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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